

Date: Tuesday, 12/05/2009 11:38:21 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206L BASKET LID		
Job Number	: 45544B			Part Number	: D2252043		
Estimate Number	: 11274			Drawing Number	: D2252 REV.G		
P.O. Number	:			Project Number	: N/A		
This Issue	: 12/05/2009	S.O. No.	:	Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 22/05/2009		Qty: 1 Um: Each
Previous Run	: 47904B						
Written By	:						
Checked & Approved By	: JLD 09.05.12						
Comment	: Est Rev:I REVISED AS PER REV E 05-12-06 JLM Est Rev:J 08-09-09 revF as per dwg (ecn 08-522) DD verified by:EC Est Rev K 09.03.18 Rev.G ecn 09-532 EC verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	E
		Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s) 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch: N/A E	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	N/A E
		Comment: LARGE FABRICATION RESOURCE 1 1- Cut ribs as required and weld as per DWG D2252	
3.0	D22211	Rib	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib B46333 PD 09-05-21	
4.0	D22521	Frame	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Frame B46824 PD 09-05-21	
5.0	D22527	Frame	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Frame B46829 PD 09-05-21	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45544B		Part Number: D2252043
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D225223	Frame 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	Pick: Frame	B46828 PD 09-05-21
7.0	D23273	Spacer Bushing 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	Pick: Qty Part Number Description Batch	1 D2327-3 Bushing B44365 PD 09-05-21
8.0	D2329	Label Plate 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	Pick: Qty Part Number Description Batch	1 D2329 Label Plate B35686 PD 09-05-21
9.0	D2581	Mounting Bracket 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	Pick: Qty Part Number Description Batch	2 D2581 Mounting Chanel B46086 PD 09-05-21
10.0	D298919	Rib 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	Pick: Rib	B47954 PD 09-05-21
11.0	D37491	Hinge Half 
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)	Pick: Hinge Half	B38826 PD 09-05-21
12.0	M304EX07516F	Expanded Metal Flat SS 
Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)	Pick: Qty Part Number Description Batch	18 sf M304EX0.75-16F Expanded Metal M111630 SAW 09-05-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45544B		Part Number: D2252043
Job Number:		
Seq. #:	Machine Or Operation:	Description :
13.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld as per Dwg D2252 using Welding Table and corner Jig Deburr as required A/R SS ROD Batch: M108160		
PQ 09-05-21		
14.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		
PQ 09-05-22		
15.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
S 09-05-25 Q		
16.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
M 111472 PRESSURE WASH DR 09-05-25 Q.		
1st COAT → START TIME: 2:45 pm 2nd COAT START TIME 3:15 pm OVEN TEMPERATURE: 400°F overTemp: 400°F FINISH TIME: 3:15 pm FINISH TIME 3:45 pm		
17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
Umo1 PR 09/05/20 (Q)		
18.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PPP 45544		
PQ 09-05-25 Q		
19.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		
09/06/01 JJ		
Job Completion		
MF 09-06-01		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-DS-14	13	Drill hole in 2252-1 as per Dwg 2252 and weld D2327-3					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3	X		D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

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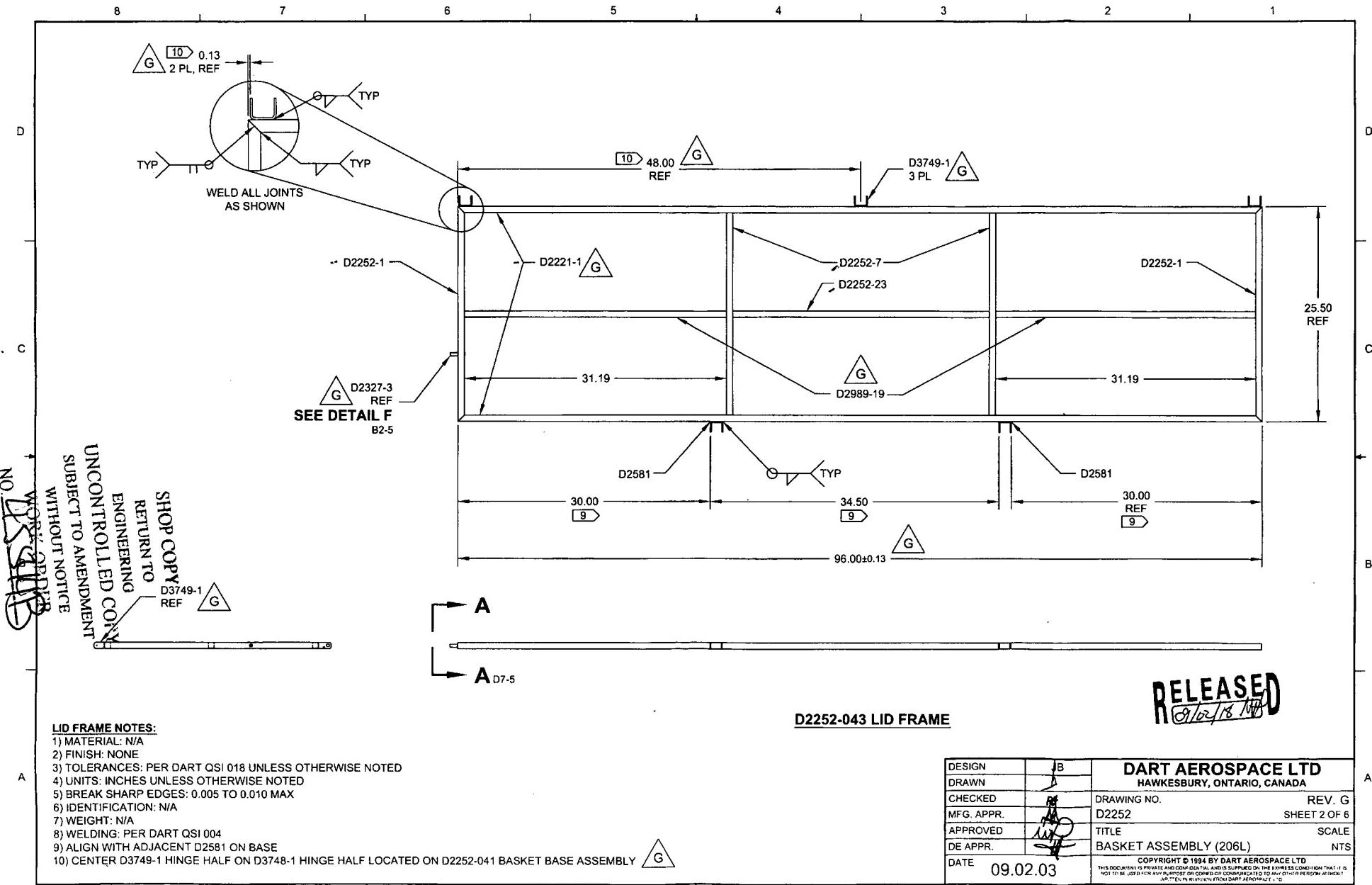
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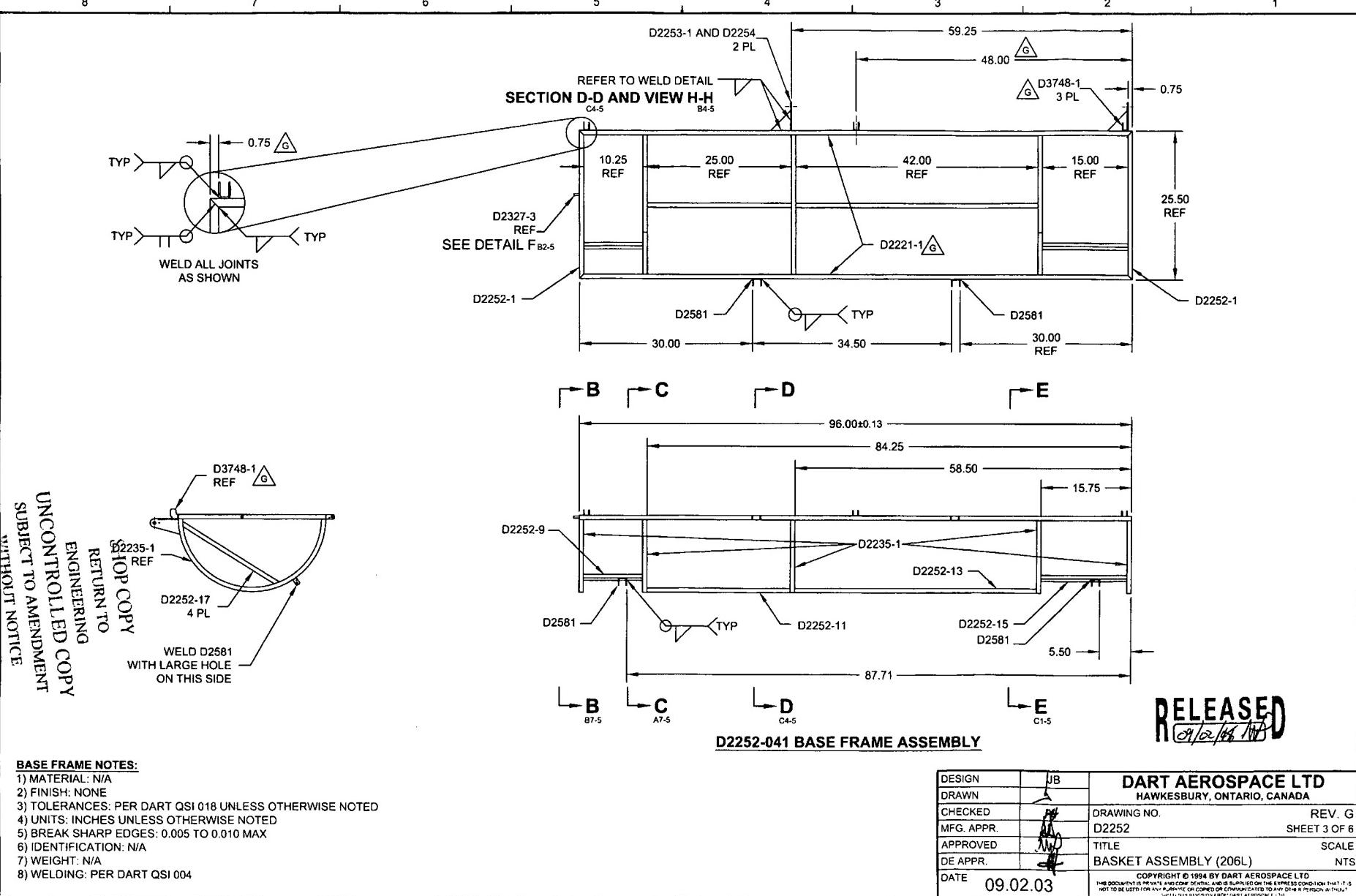
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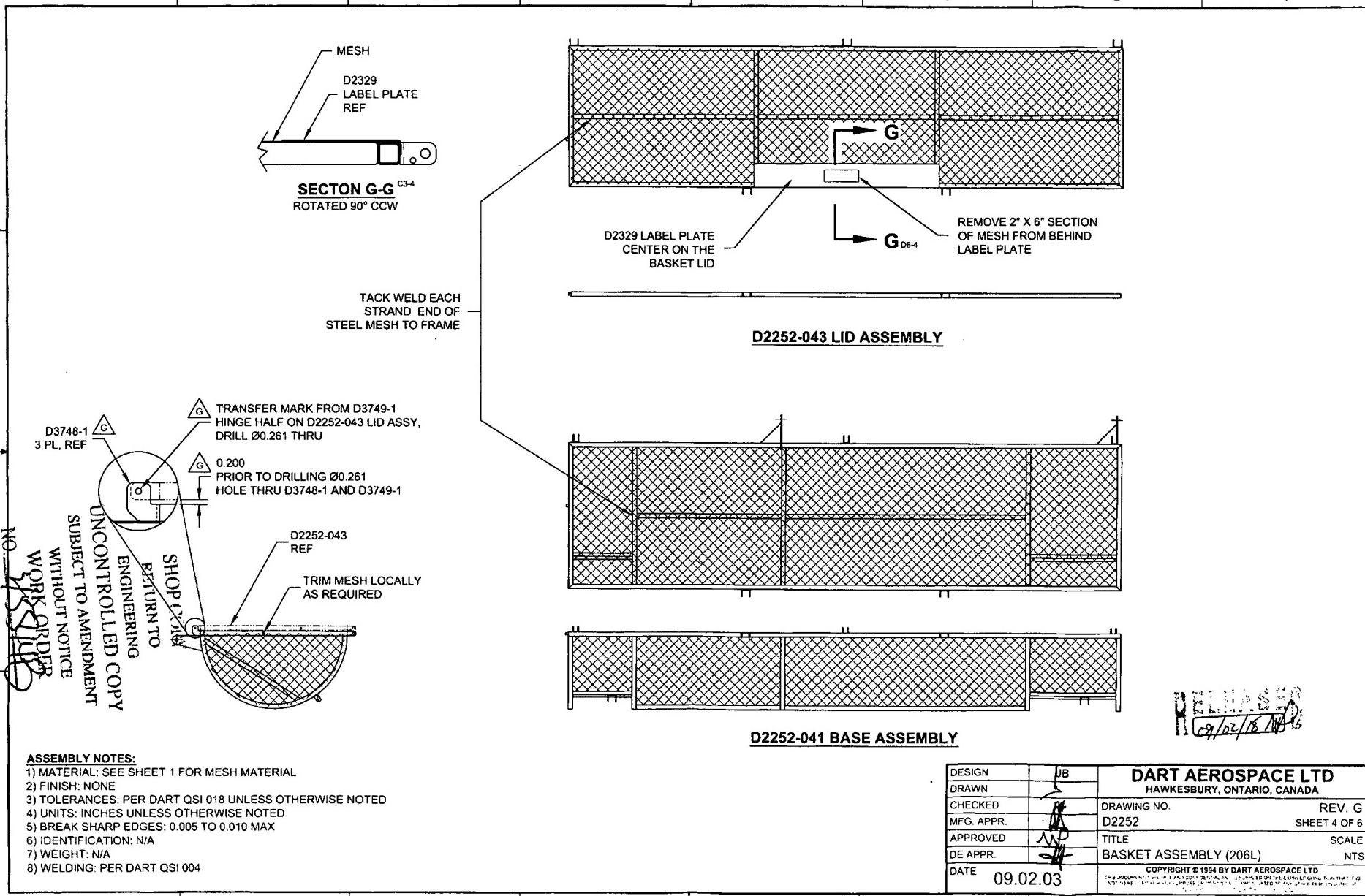
- NOTES:
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
 REF. DART SPEC M304TS0.750W.065
 - 2) MESH MATERIAL: 3/4-16F EXPANDED SS
 REF DART SPEC M304EX0.75-16F
 - 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: N/A
 - 9) WELDING: PER DART QSI 004

RELEASED
8/10/18 MM

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2322-1/3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D2252	
CHECKED		REV. G SHEET 1 OF 6	
MFG. APPR.		TITLE SCALE BASKET ASSEMBLY (206L) NTS	
APPROVED		DATE 09.02.03	
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED. NO COPIES ARE TO BE MADE OF THIS DOCUMENT.	

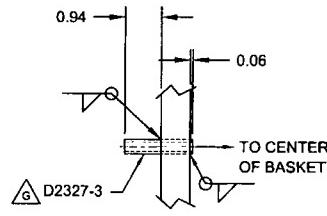
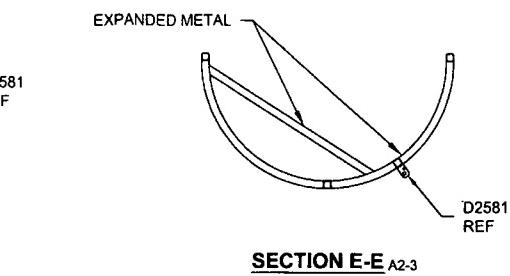
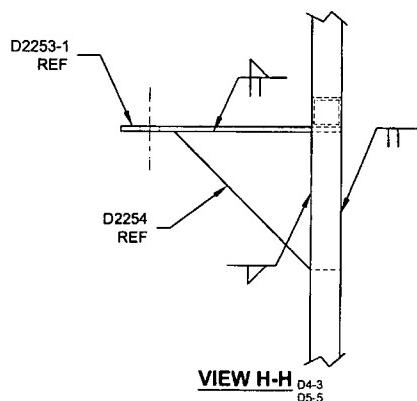
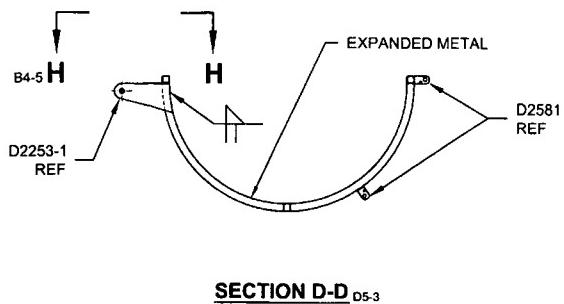
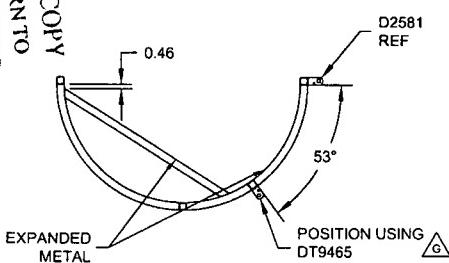
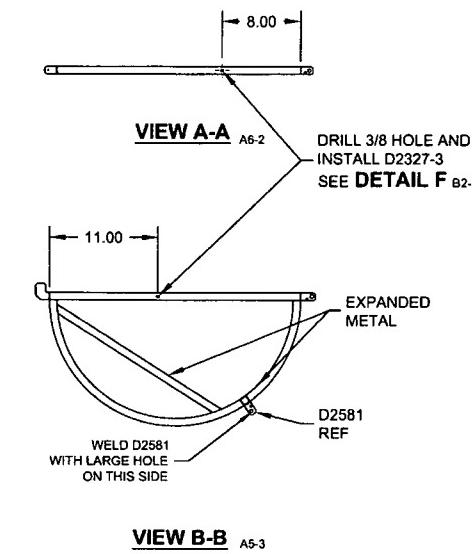






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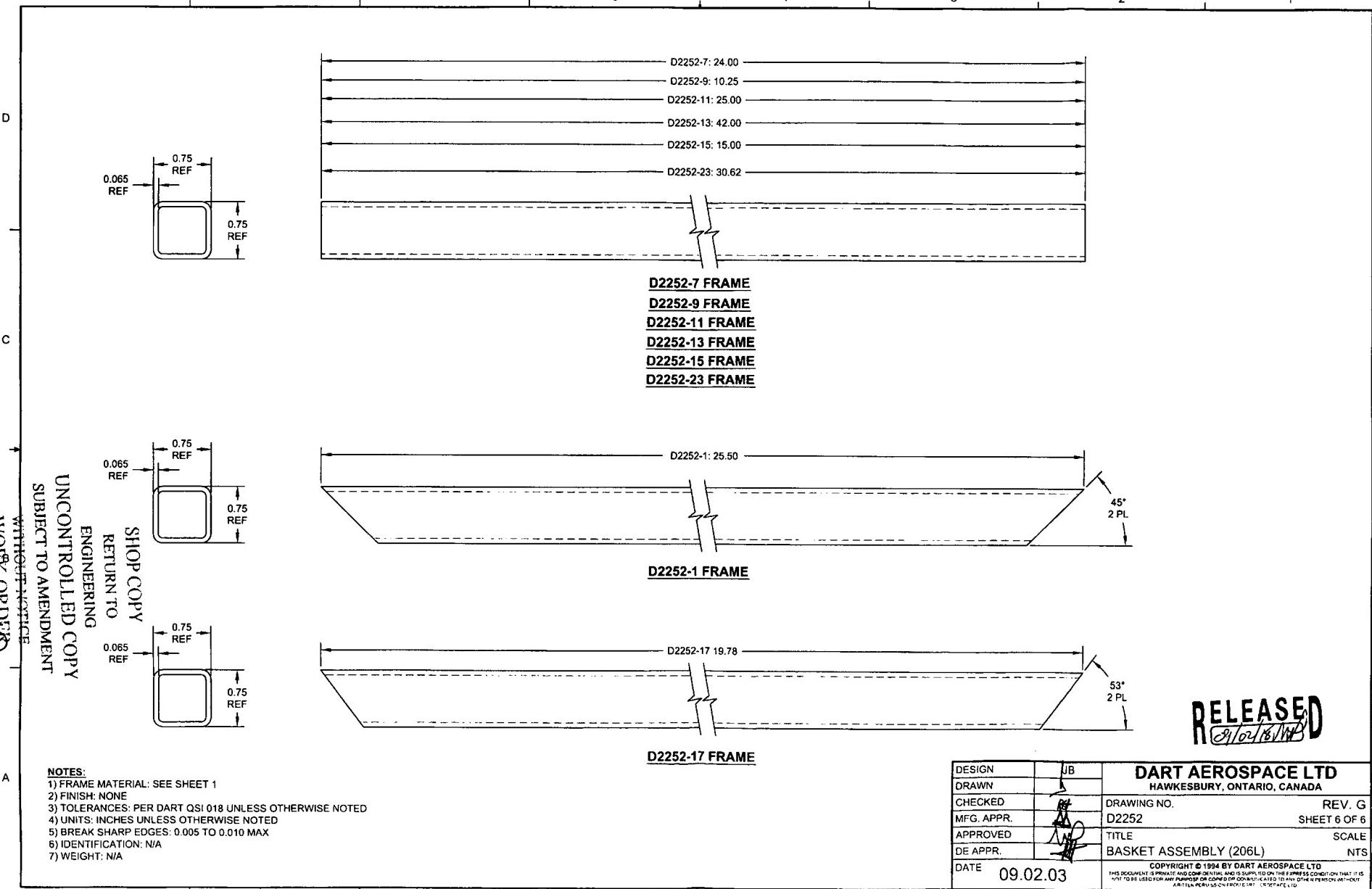
DETAIL F C5-3
SPACER INSTALLATION C6-2

RELEASED
09/07/03 MP

DESIGN	JF	DART AEROSPACE LTD
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CHECKED		REV. G
MFG. APPR.		D2252 SHEET 5 OF 6
APPROVED	JMP	TITLE
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DATE	09.02.03	NTS

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